FONTECOAT EP PRIMER

DESCRIPTION
A two component waterborne epoxy primer.

PRODUCT FEATURES AND RECOMMENDED USES
♦ Used as a primer for steel surfaces in epoxy and polyurethane paint systems.
♦ Recommended as a primer for haulage equipment, cranes, steel masts, conveyors and other steelwork, machinery and equipment.
♦ Can be used on ships for surfaces above water line.

TECHNICAL DATA

Volume solids 47 ± 2 %. (ISO 3233)
Weight solids 60 ± 2 %.
Specific gravity 1.3 kg / l (mixed)
Mixing ratio and product codes
Base 1 part by volume 007 1001-5
Hardener 1 part by volume 007 1019
Pot life 1½ h (23 ºC / 74 ºF)

<table>
<thead>
<tr>
<th>Recommended film thicknesses</th>
<th>Theoretical coverage</th>
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<tbody>
<tr>
<td>dry 50 µm</td>
<td>105 µm</td>
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<tr>
<td>wet 50 µm</td>
<td>105 µm</td>
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<tr>
<td>70 µm</td>
<td>150 µm</td>
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<td></td>
<td>9.4 m²/l</td>
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<tr>
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<td>6.7 m²/l</td>
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Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated.

Drying time
DFT 60 µm
+ 15 ºC 4 h 2 h 1 h
+ 23 ºC 8 h 4 h 2 h
+ 35 ºC 12 h 6 h 3 h

Recoatable, by itself
48 h 24 h 12 h

Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation.

Finish
Semigloss.

Colours
Red TVT 4000, grey TVT 4004 etc.
The above information, based on laboratory tests and practical experience, has been proved valid at the date marked on the product data sheet. When necessary verify the validity of the product data sheet. The quality of the product is ensured by our operational system, based on the requirements of the standards ISO 9001 and ISO 14001. As a manufacturer we cannot be responsible for any damages caused by using the product against our instructions or for inappropriate purposes.

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**APPLICATION DETAILS**

**Surface preparation**

Oil, grease, salts and dirt are removed by appropriate means. (ISO 12944-4)

*Steel surfaces:* Blast clean to grade Sa2½. (ISO 8501-1) If blast cleaning is not possible, phosphating is recommended for cold rolled steel to improve adhesion.

*Primed surfaces:* Oil, grease, salt and dirt are removed from the surface by appropriate means. Repair any damage to the primer coat. Note the overcoating time of primer. (ISO 12944-4)

**Primer**

FONTECOAT EP PRIMER and TEMACOAT GPL-S PRIMER.

**Finish**

FONTECOAT EP 50, FONTECOAT EP 80, FONTEDUR 90, TEMACOAT GPL, TEMACOAT GS 50, TEMADUR and TEMATHANE.

**Application conditions**

All surfaces must be dry. The temperature of the ambient air, surface or paint should not fall below +15 °C / 59 °F during application and drying. Relative humidity should not exceed 70 %. The surface temperature of the steel should remain at least 3 °C / 38 °F above the dew point.

**Mixing components**

First stir base and hardener separately. The correct proportions of base and hardener must be mixed thoroughly before use. Use a mechanical agitator for mixing.

**Application**

By airless spray or brush. If necessary, the paint can be thinned maximum 5 %. Airless spray nozzle tip 0.013" - 0.015"; spray angle shall be chosen according to the shape of the object.

**Thinner**

Water.

**Cleaning of equipment**

Water or a mixture of water and Thinner 1029, 1:1. The equipment must be cleaned immediately after use before the paint dries.

**VOC**

The Volatile Organic Compounds amount to 60 ± 5 g/litre of paint.

**HEALTH AND SAFETY**

Containers are provided with safety labels, which should be observed. Further information about hazardous influences and protection are detailed in individual health and safety data sheets.

A health and safety data sheet is available on request from Tikkurila Coatings Oy.

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